The listing of claims will replace all prior versions, and listings, of claims in this application:

Listing of Claims:

Claims 1-16 Cancelled

17. (Original) A method of manufacturing a crankcase for a small engine comprising the steps of casting a crankcase having a crankcase chamber, first and second bearing recess at an end of said crankcase chamber, each recess being defined by a cylindrical sidewall having a plurality of rounded radially inwardly directed flutes formed thereon, and pressing a roller bearing into each recess.

18. (Original) A method of manufacturing a crankcase according to claim 17, wherein the flutes are evenly spaced about the cylindrical sidewalls and are separated by arcuate sidewall portions.

19. (Original) A method of manufacturing a crankcase according to claim 18, wherein the flutes in said first bearing recess are offset an arcuate distance with respect to the flutes in said second bearing recess.

20. (Original) A method of manufacturing a crankcase according to claim 19, wherein said arcuate distance corresponds to said arcuate dimension.

21. (Original) A method of manufacturing a crankcase according to claim 20, wherein the number of balls in said ball bearing do not equal the number of flutes in a bearing recess.

22. (Original) A method of manufacturing a crankcase according to claim 20, wherein the number of balls in said ball bearing are greater than the number of flutes in a bearing recess.

23. (Original) A method of manufacturing a crankcase according to claim 20, wherein there are eight balls in a ball bearing and seven flutes in a bearing recess.

24. (Original) A method of manufacturing a crankcase according to claim 17, wherein each roller bearing is pressed into each recess until it seats on said toroidal base.

Claims 25-36 Cancelled